

# Work Order ID 59556

June 8, 2010 7:23:40 AM



Page 1

Item ID: D3284-001

Accept



Setup Start



Revision ID:

Stop



Item Name: Sleeve

Start Date: 6/08/10 Start Qty: 4.00



Cust Item ID:

Required Date: 6/08/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3284

Rev A

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 12035 to Northern Aero Industries ☐ Order P/N: B80702-  
☐ Manufacture per B80702 Rev. A ☐ Certificate of Conformity is required

*CL 10/6/8 (4)*

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

*Rec'd 6/11 (4)*

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Visually inspect parts for thread damage, fit and cad plating

*S. Solach*

*(4)*

*-test with D3284-003/-005/-007  
fit of thread square*

# Work Order ID 59556

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Item ID: D3284-001

Accept



Setup Start



Revision ID:

Stop



Item Name: Sleeve

Start Date: 6/08/10 Start Qty: 4.00



Cust Item ID:

Required Date: 6/08/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: 49

0.00

Memo

0.00

10-6-11 SF J/S

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/11 J/S

W 10-06-11

# Picklist Print

June 8, 2010 7:23:39 AM

Page 1

Work Order ID: 59556



Parent Item: D3284-001



Parent Item Name: Sleeve


Start Date: 6/08/10

Required Date: 6/08/10

Comments: IPP B04.10.21 Added Step 4 KJ/JLM

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
B80702-1  Sleeve		Purchased	No			110	Each	0.0000	1	4			

*Per 6/11*

## SPECIFICATION CONTROL DRAWING

DART P/N	SPECIFICATION
D3284-001 SLEEVE	ACS P/N B80702-1 PER ACS DWG B80702 REV. A
D3284-003 STUD	ACS P/N B80703-1 PER ACS DWG B80703 REV. A
D3284-005 STUD	ACS P/N B80704-1 PER ACS DWG B80704 REV. A
D3284-007 STUD	ACS P/N B80705-1 PER ACS DWG B80705 REV. B
D3284-009 BEARING	BHT P/N 47-140-252-5
D3284-011 BEARING	BHT P/N 205-060-101-001
D3284-021 TUBE ASSY	204-060-158-001 MODIFIED PER IIN-D205-708
D3284-023 BIPOD ASSY	204-060-155-001 MODIFIED PER IIN-D205-708
D3284-025 TRIPOD ASSY	204-060-157-001 MODIFIED PER IIN-D205-708
D3284-031 TUBE ASSY	205-060-107-001 MODIFIED PER IIN-D205-708
D3284-033 BIPOD ASSY	205-060-106-001 MODIFIED PER IIN-D205-708
D3284-035 TRIPOD ASSY	205-060-105-001 MODIFIED PER IIN-D205-708



**NOTE:**

FOR FUTURE PROCUREMENT, THE PURCHASE ORDER MUST SPECIFY THAT THE MATERIAL USED TO MANUFACTURE THE D3284-001/-003/-005/-007 PARTS MUST COMPLY WITH THE FOLLOWING SPECIFICATIONS:

AISI 4130 ROUND BAR PER AMS 6348/MIL-S-6758 WITH  
 MIN Ft<sub>u</sub> = 90 Ksi  
 MIN Ft<sub>y</sub> = 70 Ksi

EACH INDIVIDUAL ITEM TESTED BEFORE USE OR PROVEN TO EQUAL OR EXCEED THE ABOVE.

*CL 10/6/8*

*W10: 59556*

**RELEASED**  
 2010-03-25

B	ADD NOTE	RF	09.07.14
A	NEW ISSUE	KJ	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3284	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ADJUSTABLE ENGINE MOUNT	NTS
DATE	09.07.14	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO12035

Purchase Order Date 6/08/10

PO Print Date 6/08/10

Page Number 1 of 1

Order From :

VU-NOR003

NORTHERN AERO INDUSTRIES LTD.  
25 DUNLOP AVENUE  
WINNIPEG, MB R2X 2V2  
CA

Contact Name  
Vendor Phone 204-772-9922  
Vendor Fax 204772-7568  
Vendor Account Nbr

Buyer Chantal Lavoie  
Requisition Nbr  
Tax Resale Nbr 10127-2607  
Terms Net 30  
Currency USD  
FOB

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAXED**  
6/10/10

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	B80702-1	Sleeve	6/11/10 Yes	4.00 Each	FedEx PI ppd	\$117.0000	\$468.00

Special Inst: AS PER DWG D3284 REV. A  
B59556  
P/N: 80702-1 PER ACS DWG B80702  
REV. A

PO Total:

\$468.00

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 6/08/10

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

**ACS-NAI Ltd.**

25 Dunlop Avenue  
R2X 2V2 Winnipeg  
Canada  
Tel : 204-772-9922  
Fax : 204-772-7568

Delivery No. : 963  
Delivery Date : 06/08/2010  
SO No. : 23028  
Your Reference : PO: PO12035  
Delivery Method : FEDEX ACCT# 2351 4353 4  
Payment Condition : Net 30 Days

**Delivery to:** Dart Aerospace Ltd.

Attention: Chantal Lavoie  
1270 Aberdeen Street

Hawkesbury K6A 1K7  
Canada

Item	Description Batch Number	Total Ordered Unit	Qty Delivered	Delivery Date
B80702-1	SLEEVE 08-1874	4 EA	4	06/11/2010

CURRENCY: US FUNDS  
SHIP VIA: FEDEX ACCT# 151793240  
ORDERED BY: CHANTAL LAVOIE @ 613-632-9577  
TAX #: 10127-2607

*8/10/2010*

Packages: 0

Gross Weight: 0.00

Net Weight:

**Ordered by:** Dart Aerospace Ltd.

Attention: Chantal Lavoie  
1270 Aberdeen Street

Hawkesbury K6A 1K7  
Canada

**Invoice to:** Dart Aerospace Ltd.

Attention: Accounts  
1270 Aberdeen Street

Hawkesbury K6A 1K7  
Canada

0.00

**Remarks****Certification Statement**

I hereby certify that the aircraft part(s) described hereon were acquired from a source of supply that is consistent with the conditions under which TCCA distributor approval AMO88-97 has been granted.

\_\_\_\_\_  
Signatory

\_\_\_\_\_  
Date:



Engineering, Certification & Manufacturing

25 Dunlop Ave  
Winnipeg, Manitoba, Canada, R2X 2V2  
Ph: 204-772-9922 Fax: 204-772-7568

### CERTIFICATE OF CONFORMITY

Form Tracking No.23028-1		Work Order/Contract/Invoice PO: PO12035		Cage Code: MFR L0555	
Item 1	Description Sleeve	Part No. B80702-1	Quantity 4	Serial/Batch 08-1874	Status manufactured

S10664

#### Remarks:

THIS ITEM CONFORMS TO APPROVED DESIGN DATA B80702 (REV. A).

DETAILS OF THE WORK PERFORMED ARE RECORDED ON ACS-NAI WORK ORDER # WO18601.

#### New-Unused Parts/Material Certification

The items described above have been manufactured using standards employed by a TCCA approved manufacturer in accordance with CAR 561 and a AS9100 Quality Assurance System.

Signature

Name R. D. WILLIAMSON

Date (dd mmm yyyy)  
08 JUN 10

#### Used, Repaired or Overhauled Parts Certification

The items described above have been maintained using standards employed by a TCCA approved maintenance organization in accordance with CAR 573 and a AS9100 Quality Assurance System.

Signature

Name

Date (dd mmm yyyy)

User/Installer Responsibilities: This certificate does not constitute authority to install the item(s) described above on an in-service type certified aircraft.